

CLAIMS

1. A method of making a plastics stretch film comprising the steps of:-
- 5 a) taking a cast or blown film of LLDPE at a temperature of between 50°C and 100°C;
- b) causing both plastic and elastic deformation of the film by stretching it in two successive stretching steps, said first step having a stretch ratio higher than that of
- 10 said second step to form a stretched film;
- c) relaxing said stretched film substantially to release all of the elastic deformation to form a substantially relaxed film; and
- d) winding said substantially relaxed film into a
- 15 roll.
2. A method of making a plastics stretch film as claimed in claim 1, wherein the temperature of said film is between 75°C and 90°C during said stretching steps.
- 20 3. A method of making a plastics stretch film as claimed in claim 2, wherein the temperature of said film is substantially 80°C during said stretching steps.
- 25 3. A method of making a plastics stretch film as claimed in claim 1, wherein the stretching of the film that occurs in said two successive steps has a stretch ratio in a range from 1:1.5 to 1:2.5 for each step.
- 30 4. A method of making a plastics stretch film as claimed in claim 1, wherein the stretching of the film that occurs in said first step has a stretch ratio in the range 1:1.85 to 1:1.95.
- 35 5. A method of making a plastics stretch film as claimed in claim 1, wherein the stretching of the film that occurs

in said second step has a stretch ratio in the range 1:1.70 to 1:1.80.

5 6. A method of making a plastics stretch film as claimed in claim 1, wherein the stretching of the film that occurs in said first step has a stretch ratio in the range 1:1.85 to 1:1.95 and wherein the stretching of the film that occurs in said second step has a stretch ratio in the range 1:1.70 to 1:1.80.

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7. A method of making a plastics stretch film comprising the steps of:-

a) taking a cast or blown film of LLDPE at a temperature of between 50°C and 100°C;

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b) causing both plastic and elastic deformation of the film by stretching it in two successive stretching steps, said first step having a stretch ratio higher than that of said second step, wherein during said second step said film is traveling at a first speed; and

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c) relaxing said stretched film by winding said film into a roll at a speed 0.85 times said first speed.

8. A method of making a plastics stretch film as claimed in claim 7, wherein the temperature of said film is between 25 75°C and 90°C during said stretching steps.

9. A method of making a plastics stretch film as claimed in claim 8, wherein the temperature of said film is substantially 80°C during said stretching steps.

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10. A method of making a plastics stretch film as claimed in claim 7, wherein the stretching of the film that occurs in said two successive steps has a stretch ratio in a range from 1:1.5 to 1:2.5 for each step.

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11. A method of making a plastics stretch film as claimed in claim 7, wherein the stretching of the film that occurs

in said first step has a stretch ratio in the range 1:1.85 to 1:1.95.

5 12. A method of making a plastics stretch film as claimed in claim 7, wherein the stretching of the film that occurs in said second step has a stretch ratio in the range 1:1.70 to 1:1.80.

10 13. A method of making a plastics stretch film as claimed in claim 7, wherein the stretching of the film that occurs in said first step has a stretch ratio in the range 1:1.85 to 1:1.95 and wherein the stretching of the film that occurs in said second step has a stretch ratio in the range 1:1.70 to 1:1.80.

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